

Date: Friday, 13/06/2008 10:47:12 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HELI ACCESS STEP HIGH GEAR LH
Job Number	: 39859		
Estimate Number	: 12434		
P.O. Number	:	Part Number	: D205633021
This Issue	: 13/06/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: DSI 9300 REV B
First Issue	: / /	Project Number	: N/A
Previous Run	: 37063	Drawing Revision	: B
	Type	Material	:
	: LARGE FAB ASSY	Due Date	: 30/06/2008
Written By	:	Qty:	4 Um: Each
Checked & Approved By	: <u>JUL 08.6.13</u>		
Comment	: Est Rev:B Added D2565-111 05-09-09 KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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HJ for JLD 09/02/25



Comment: Photocopy bluefile & type labels per PPPD205-633-021 CHG001

09/02/25

2.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

3.0	D2022101	Spacer
-----	----------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Spacer

Batch:

B39880

AS 09/02/25 (x4)

4.0	D2022103	Spacer
-----	----------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Spacer

Batch:

B38329

AS 09/02/25 (x4)

5.0	D2562011	Strut
-----	----------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Strut

Batch:

39882

AS 09/02/25 (x4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 13/06/2008 10:47:12 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACCESS STEP HIGH GEAR LH

Job Number: 39859

Part Number: D205633021

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	D2563	Step Weldment Assembly
-----	-------	------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Step Weldment Assembly

Batch: 45162

7.0 D2565101



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Strut

Batch: 41892

8.0 D2565103



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Strut

Batch: 41893

9.0 D2565105



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Strut

Batch: 41894

10.0 D2565107



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Strut

Batch: 41895

11.0 D2565109



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Strut

Batch: 4202

12.0 D2565111



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Strut

Batch: 41896

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 13/06/2008 10:47:12 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACCESS STEP HIGH GEAR LH

Job Number: 39859

Part Number: D205633021

Job Number:



Seq. #:	Machine Or Operation:	Description :
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13.0	D3437041	Aft Strut Assembly
------	----------	--------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Aft Strut Assembly
Batch: 39869

SS 09/02/25 (x4)

14.0	AN45A	Bolt
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Bolt
Batch: 10906

SS 09/02/25 (x4)

15.0	AN46A	Bolt
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)
Bolt
Batch: M109545

SS 09/02/25 (x4)

16.0	AN47A	Bolt
------	-------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Bolt
Batch: 108924

SS 09/02/25 (x4)

17.0	AN411A	Bolt
------	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Bolt
Batch: 106605

SS 09/02/25 (x4)

18.0	AN414A	Bolt
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Bolt
Batch: M167534

SS 09/02/25 (x4)

19.0	AN44 7A	AN44 7A EYEBOLT EYEBOLT
------	---------	-------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
EYEBOLT
Batch: M100446

SS 09/02/25 (x4)

*****ENSURE THIS IS AN44-7A EYEBOLT*****

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: HELI ACCESS STEP HIGH GEAR LH

Job Number: 39859

Part Number: D205633021

Job Number:



Seq. #:	Machine Or Operation:	Description :
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20.0	AN514A	Bolt
------	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M106166

21.0	AN960JD416	Washer
------	------------	--------



Comment: Qty.: 16.0000 Each(s)/Unit Total : 64.0000 Each(s)

Washer

Batch: M110523

22.0	AN960JD516	Washer
------	------------	--------



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Washer

Batch: M110363

23.0	MS21042L4	Nut
------	-----------	-----



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Nut

Batch: M109282

24.0	MS21042L5	Nut
------	-----------	-----



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Nut

Batch: 110362

25.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: INSPECT 100% KITS FOR COMPLETENESS

26.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-633-021

Location: A

PPP Rev: 146/25 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

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Drawing Name: HELI ACCESS STEP HIGH GEAR LH

Job Number: 39859

Part Number: D205633021

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

QC21

FINAL INSPECTION/W/O RELEASE



09/02/25 kg

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



h 09.02.25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DSI 9300	REV. B SHEET 1 OF 6
DATE 05.08.12		TITLE SIMPLEX TANK STEP	SCALE NTS
A	05.05.05	NEW ISSUE	
B	05.08.12	ADD STRUTS IF TANK REMOVED	

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D205-633 REV. A

REF. CANADIAN STC: SH96-57

REF. FAA STC: SR00592NY, SR00593NY, SR00594NY

THE PURPOSE OF THIS SERVICE INSTRUCTION IS TO ADD THE D205-633-021/-022/-023/-024/-025/-026 STEPS TO ADDRESS COMPATABILITY WITH THE SIMPLEX MODEL 304 FIRE ATTACK TANK. D205-633-021/-022 ARE IDENTICAL TO D205-633-011, EXCEPT AS SHOWN HERE. D205-633-023/-024 ARE IDENTICAL TO D205-633-013, EXCEPT AS SHOWN HERE. D205-633-025/-026 ARE IDENTICAL TO D205-633-015, EXCEPT AS SHOWN HERE.

NOTE THAT THE STRUTS REQUIRED TO INSTALL THE STEPS ON THE LOWER AFT HARDPOINT HAVE ALSO BEEN INCLUDED WITH THE KITS IN CASE THE TANK IS REMOVED FOR ANY REASON. THESE STRUTS SHOULD BE INSTALLED I.A.W. IIN-D205-633, EXCEPT REPLACE EYEBOLT WITH AN4 BOLT ON LOWER HARDPOINT. ALSO NOTE THAT IF THE THREADS PROTRUDE THROUGH THE BAR ON THE D3437-XXX STRUT ASSEMBLIES AFTER ADJUSTMENT THEY MAY BE TRIMMED OFF.

WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D205-633-021 <i>HELI-ACCESS-STEP™</i>	14.0 lb 6.35 kg	-50.0 in -1.27 m	-700 in lb -8.06 m kg	94.5 in 2.40 m	1323 in lb 15.24 m kg
D205-633-022 <i>HELI-ACCESS-STEP™</i>	13.2 lb 6.00 kg	+50.0 in +1.27 m	+660 in lb +7.62 m kg	94.5 in 2.40 m	1247 in lb 14.40 m kg
D205-633-023 <i>HELI-ACCESS-STEP™</i>	14.3 lb 6.50 kg	-50.0 in -1.27 m	-715 in lb -8.26 m kg	94.5 in 2.40 m	1351 in lb 15.6 m kg
D205-633-024 <i>HELI-ACCESS-STEP™</i>	13.5 lb 6.14 kg	+50.0 in +1.27 m	+675 in lb +7.80 m kg	94.5 in 2.40 m	1276 in lb 14.74 m kg
D205-633-025 <i>HELI-ACCESS-STEP™</i>	14.6 lb 6.64 kg	-50.0 in -1.27 m	-730 in-lb -8.43 m-k-g	94.5 in 2.40 m	1380 in-lb 15.94 m-k-g
D205-633-026 <i>HELI-ACCESS-STEP™</i>	13.8 lb 6.27 kg	+50.0 in +1.27 m	+690 in-lb +7.96 m-k-g	94.5 in 2.40 m	1304 in-lb 15.05 m-k-g

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BRANCH
DAO # 01-O-01

APPROVED



BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 05.08.12
CERT. NO.: SH96-57
ISSUE NO.: #5

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CHECKED 	APPROVED 	DRAWING NO. DSI 9300	REV. B SHEET 2 OF 6
DATE 05.08.12		TITLE SIMPLEX TANK STEP	SCALE NTS

PARTS LIST

QTY -021	QTY -022	QTY -023	QTY -024	QTY -025	QTY -026	Part Number	Description
X						D205-633-021	Heli-Access-Step™ (LH), High Gear
	X					D205-633-022	Heli-Access-Step™ (RH), High Gear
		X				D205-633-023	Heli-Access-Step™ (LH), Extended High Gear (31")
			X			D205-633-024	Heli-Access-Step™ (RH), Extended High Gear (31")
				X		D205-633-025	Heli-Access-Step™ (LH), Extended High Gear (39")
					X	D205-633-026	Heli-Access-Step™ (RH), Extended High Gear (39")
4	4	4	4	4	4	D2022-101	SPACER
2	2	2	2	2	2	D2022-103	SPACER
				1	1	D2562-005	STRUT
1	1					D2562-011	STRUT
		1	1			D2562-013	STRUT
1		1		1		D2563	WELDMENT ASSEMBLY
				*1	*1	D3165-1	STRUT
1	1					D2565-101	STRUT
1	1					D2565-103	STRUT
1	1					D2565-105	STRUT
1	1					D2565-107	STRUT
1	1					D2565-109	STRUT
*1	*1					D2565-111	STRUT
		1	1			D2565-201	STRUT
		1	1			D2565-203	STRUT
		1	1			D2565-205	STRUT
		1	1			D2565-207	STRUT
		1	1			D2565-209	STRUT
		*1	*1			D2565-211	STRUT
				1	1	D2565-301	STRUT
				1	1	D2565-303	STRUT
				1	1	D2565-305	STRUT
				1	1	D2565-307	STRUT
				1	1	D2565-309	STRUT
1	1					D3437-041	AFT STRUT ASSEMBLY
		1	1			D3437-043	AFT STRUT ASSEMBLY
				1	1	D3437-045	AFT STRUT ASSEMBLY
	1		1		1	D3438-042	WELDMENT ASSEMBLY
1	1	1	1	1	1	AN4-5A	BOLT
4	4	3	3	3	3	AN4-6A	BOLT
1	1	1	1	1	1	AN4-7A	BOLT
1	1					AN4-11A	BOLT
		1	1	1	1	AN4-12A	BOLT
1	1	1	1	1	1	AN4-14A	BOLT
1	1	1	1	1	1	AN44-7A	EYEBOLT
1	1	1	1	1	1	AN5-14A	BOLT
16	16	14	14	14	14	AN960JD416	WASHER
3	3	3	3	3	3	AN960JD516	WASHER
8	8	7	7	7	7	MS21042L4	NUT (or MS21042-4)
2	2	2	2	2	2	MS21042L5	NUT (or MS21042-5)

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BY: 
D. SHEPHERD (DE # 02)



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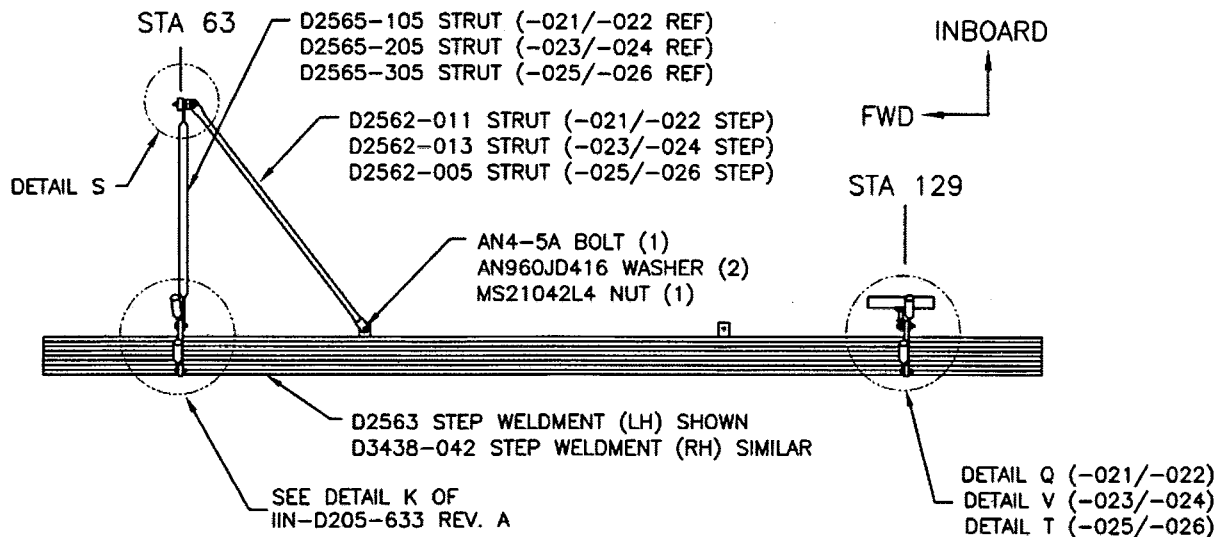
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DATE 05.08.12	TITLE SIMPLEX TANK STEP KIT		SCALE NTS

INSTALLATION OF D205-633-021/-022/-023/-024/-025/-026

INSTALL D205-633-021/-022 AS PER THE D205-633-011 STEP OF INSTALLATION INSTRUCTIONS IIN-D205-633 REV.A, EXCEPT REPLACE D2565-111 STRUT WITH THE D3437-041 AFT STRUT ASS'Y, REMOVE D2562-001 STRUT, INSTALL D2562-011 STRUT AS SHOWN.

INSTALL D205-633-023/-024 AS PER THE D205-633-013 STEP OF INSTALLATION INSTRUCTIONS IIN-D205-633 REV.A, EXCEPT REPLACE D2565-211 STRUT WITH THE D3437-043 AFT STRUT ASS'Y, REMOVE D2562-003 STRUT, INSTALL D2562-013 STRUT AS SHOWN.

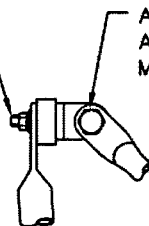
INSTALL D205-633-025/-026 AS PER THE D205-633-015 STEP OF INSTALLATION INSTRUCTIONS IIN-D205-633 REV.A, EXCEPT REPLACE D3165-1 SUPPORT ARM WITH THE D3437-045 AFT STRUT ASS'Y AS SHOWN.



D205-633-021/-023/-025 SHOWN.
D205-633-022/-024/-026 SIMILAR
(VIEW LOOKING DOWN)

AN44-7A EYEBOLT (1)
AN960JD516 WASHER (1)
MS21042L5 NUT (1)

DETAIL S
NOT TO SCALE



AN4-6A BOLT (1)
AN960JD416 WASHER (2)
MS21042L4 NUT (1)

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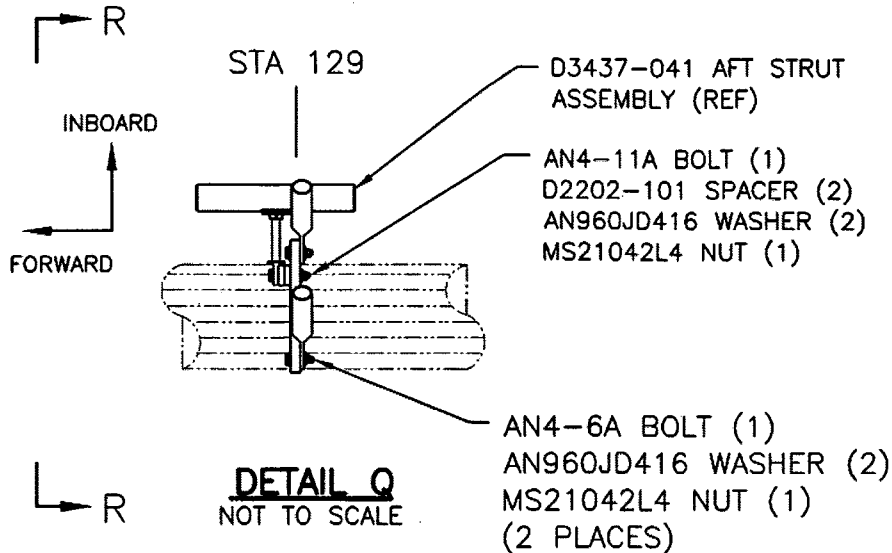
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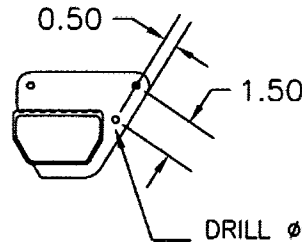
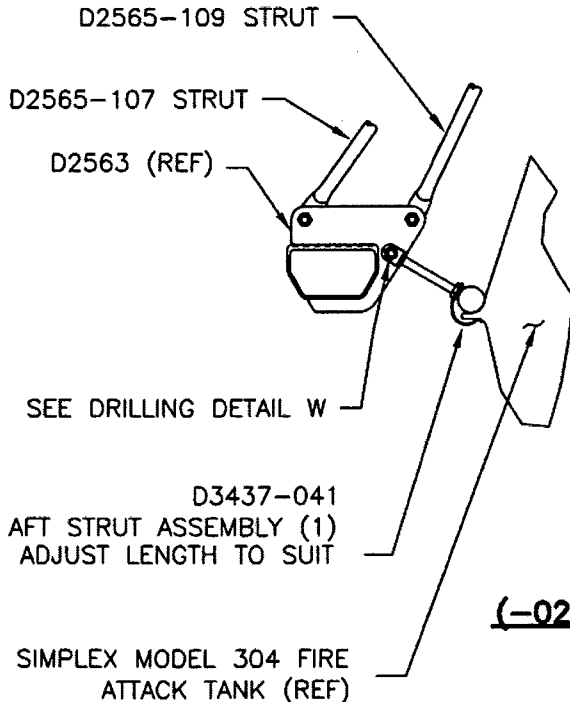
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DETAIL W

DRILL $\phi 0.257$ THRU,
TOUCH UP WITH
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(-021/-022 STEP)

VIEW R-R
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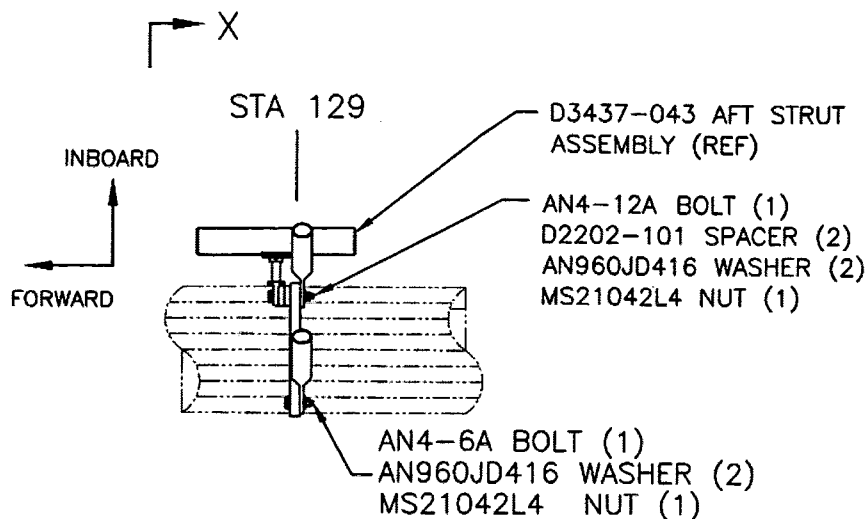
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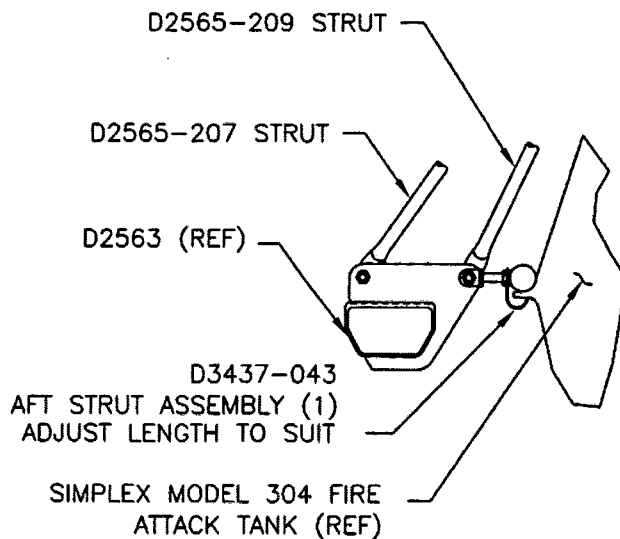
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DATE 05.08.12	TITLE SIMPLEX TANK STEP		SCALE NTS



DETAIL V
NOT TO SCALE



(-023/-024 STEP)

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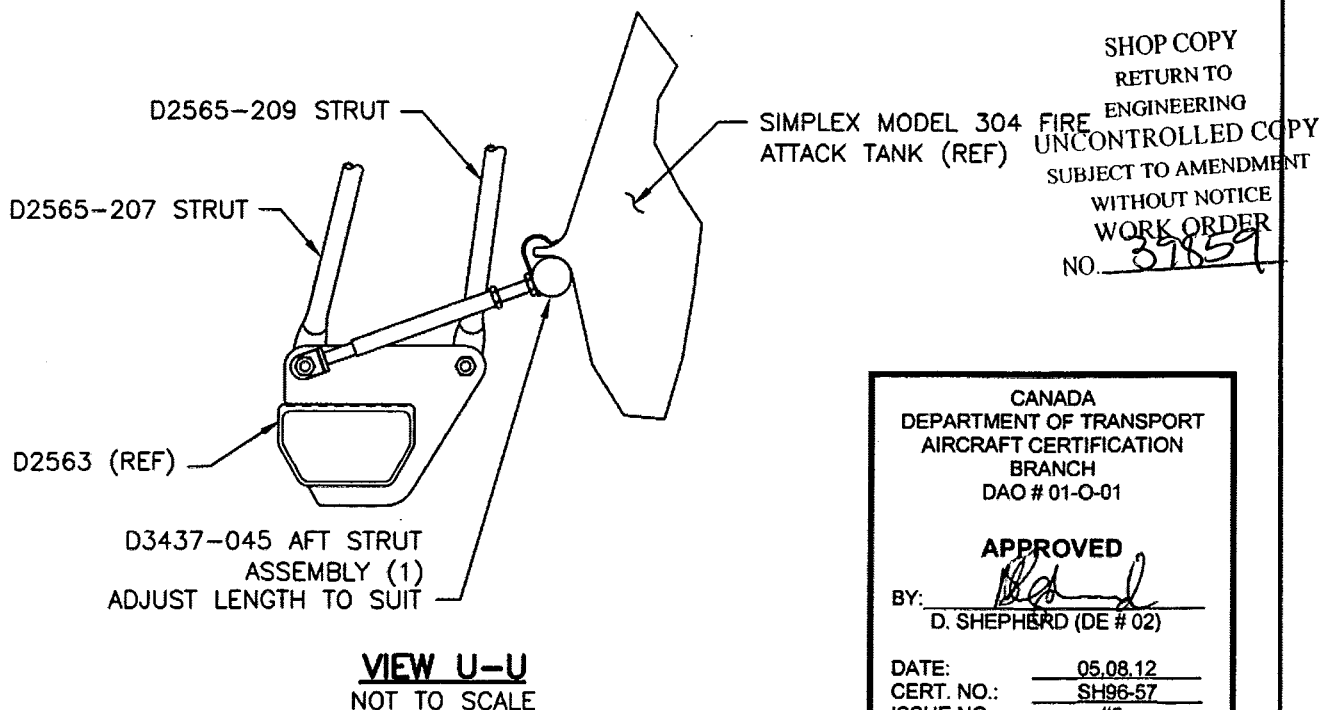
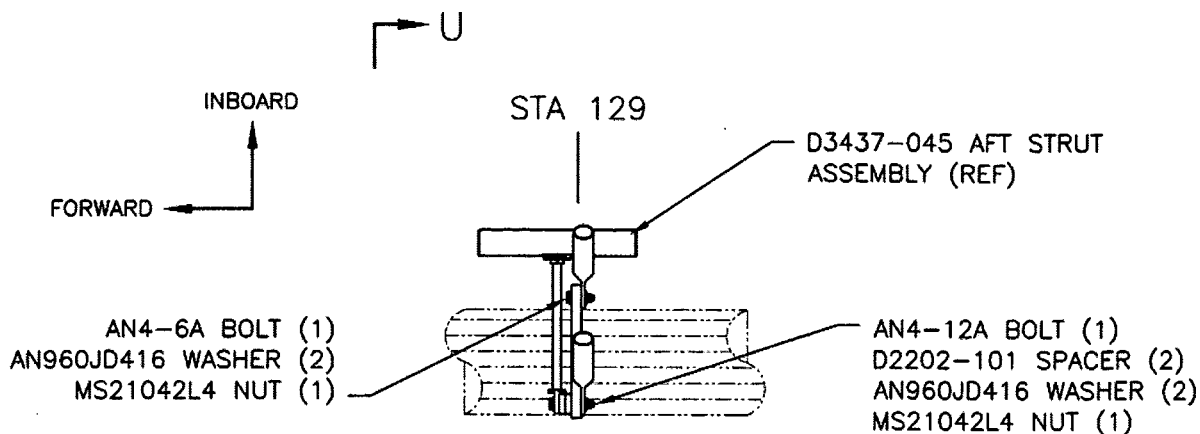
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